

Induction Brazing Copper Contacts

United Induction Heating Machine Limited

We are experienced in Induction Heating, induction heating machine, Induction Heating equipment. They are widely used in induction heating service, induction heat treatment, induction brazing, induction hardening, induction welding, induction forging, induction quenching, induction soldering induction melting and induction surface treatment applications
<http://www.uihm.com>

Objective Heat silver contacts and brass/copper bus for brazing application

Material Silver contact .75 (19mm) diameter, brass and copper bus 2" x 1" (50.8 x 25.4mm), braze shims, white flux

Temperature 1300 °F (704 °C)

Frequency 320 kHz

Equipment • Power of 10kW induction heating system, equipped with a remote workhead containing two 1.0µF capacitors for a total of 0.5 µF

- An induction heating coil designed and developed specifically for this application.

Process A five turn split helical coil is used to heat the assembly. The parts are placed 90° to the coil between the top turn and second turn with braze shims and flux. The parts reach 1300°F (704 °C) in less than 40 seconds to braze the parts together.

Results/Benefits Induction heating provides:

- Hands-free heating that involves no operator skill for manufacturing
- Better joint quality
- Faster heating cycles, more consistent results
- Even distribution of heating



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